



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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RB6795969
Job Sheet 196722



Part No: RB6795969

Job Qty: 1 pcs

Part Name: Holder Torquemeter Shaft Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 8/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16107

Note: DWG RB6795969 Rev B IPP Rev. A 19.06.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	8/2/19	0.00	0.07		Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	8/2/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	8/2/19	0.00	0.00		Packaging 3 - 1 - B4B		DAS 40 9-89 AUG 12 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S203388



Part: RB6795969

Job No: 196722

Serial No/Batch: S203388

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Date: 08/07/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130	QC 21 - FG	1 pcs	8/2/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 100 - 1-Assemble as per drawing. See note 8 and 9.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A438	Steel Dowel Pin 3/32" Dia. X 1/2" Long	1 Ea (1 ea)	100-Small Fab - 1	5196491
RB6795969-1	Shaft	1 pcs (1 ea)	100-Small Fab - 1	5199685
RB6795969-2	Socket	1 pcs (1 ea)	100-Small Fab - 1	5198878
RB6795969-3	Shank	1 pcs (1 ea)	100-Small Fab - 1	5200188
RB6795969-4	Knurl Nut	1 pcs (1 ea)	100-Small Fab - 1	5199126

Job Allocations

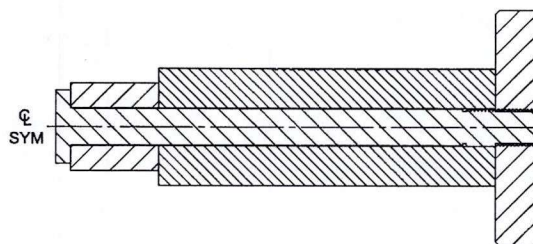
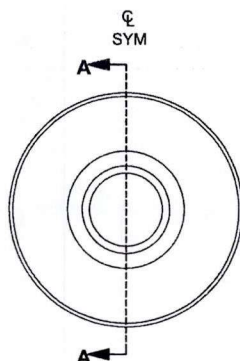
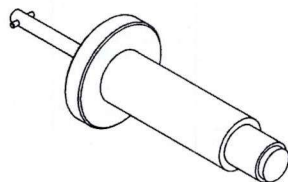
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	98381A438	1	0	0
	RB6795969-1	1	0	0
	RB6795969-2	1	0	0
	RB6795969-3	1	0	0
	RB6795969-4	1	0	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-1	1	RB6795969-1	SHAFT
-2	1	RB6795969-2	SOCKET
-3	1	RB6795969-3	SHANK
-4	1	RB6795969-4	KNURL NUT
5	1	McMaster#98381A438 OR EQUIV	STEEL DOWEL PIN 3/32" DIA. X 1/2" L.G.



SECTION A-A

RB6795969 HOLDER TORQUEMETER SHAFT SUPPORT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH:
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM -4 HAND TIGHT
- 9) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 5 CENTERED WITH ITEM -1, AND REMOVE EXCESS
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196722 MJS
190620

FOR OLD REV SEE PREVIOUS PDF TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -6 CHANGED FOR ITEM 5 ITEM -1 CENTER DRILL NOTE ADDED, MATERIAL 4140 Q&T CHANGED FOR 4140 (28-32 RC), DIMENSION 5/16-32 CHANGED FOR 5/16-24 UNF. DIMENSION $\phi .0937/.0933$ CHANGED FOR $\phi .0938/.0930$ THRU. DIMENSION $\phi .25$ CHANGED FOR $\phi .250$, DIMENSION $0.02 \times 45^\circ$ CMF ADDED, MIN THREAD RELIEF ADDED, DIMENSION ($\phi .625$) CHANGED FOR $\phi .63$, DIMENSION $\phi .31$ CHANGED FOR $\phi .312$, DIMENSION R0.02 ADDED ITEM -2 MATERIAL #107 PURE GUM RUBBER CHANGED FOR McMaster#1372N41, DIMENSION .75 CHANGED FOR .75 REF, DIMENSION $\phi .31$ CHANGED FOR $\phi .323$ ITEM -3 ENGRAVING S/N AND "MADE IN USA" REMOVED, MATERIAL 6061 WITH BLACK ANODIZE FINISH CHANGED FOR 6061-T6 / 7075-T6 WITH RED ANODIZE FINISH, DIMENSION ($\phi 1.00$) CHANGED FOR $\phi 1.00$, DIMENSION $\phi 0.34$ CHANGED FOR $\phi 0.323$ ITEM -4 MATERIAL 1018 CHANGED FOR 4140 (28-32 RC), DIMENSION ($\phi 2.00$) CHANGED FOR $\phi 2.00$		19-751	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	JFC	RB6795969	SHEET 1 OF 5
APPROVED	WAP	TITLE	SCALE
		HOLDER TORQUEMETER SHAFT SUPPORT	NTS
DATE	2019-06-12	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					